

# Work Order ID 65246

January 10, 2011 10:45:27 AM



Page 1

Item ID:	D3438-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Weldment Assembly					
Start Date:	1/10/11	Start Qty:	2.00	Cust Item ID:		
Required Date:	1/21/11	Req'd Qty:	2.00	Customer:		
Reference:						

Approvals:	Process Plan:	<i>MF</i>	Date:	<i>1-01-10</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3438	Rev A

100		0.00							
	Large Fab								
Large Fab		0.00							
Large Fab	Memo								
	1-Cut D2244 to 79.63" at 34° as per Dwg D3438 2-Deburr ends 3-Weld one cap, LUG PLATES & MOUNTING ANGLE as per Dwg D3438 using DT8343								
	4-Grind								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

*11.01.17*

*2*

*2*

*8 w/1/18*

*(+2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D3438-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment Assembly

Start Date: 1/10/11 Start Qty: 2.00



Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

⇒ H 11/10/11

2

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

H 11.01.19

2

150

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

Weld last cap per dwg D3438 & grind flush

M108436 Aluminum Rod

H 11.01.20

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Item ID: D3438-042 Accept  Setup Start   
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Item Name: Step Weldment Assembly  
Start Date: 1/10/11 Start Qty: 2.00  Cust Item ID:  
Required Date: 1/21/11 Req'd Qty: 2.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				2	0	3E 11/01/20	
170  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				(+2)			
180  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo 1-Touch up alodine <input type="checkbox"/> START TIME: TEMPERATURE: 320° FINISH TIME:	0.00  0.00							TOUCH UP ALO. 145. <input type="checkbox"/> OVEN 2:15

2 BL 11-a-20.

2 BL 11-a-20.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Item Name: Step Weldment Assembly

Start Date: 1/10/11 Start Qty: 2.00



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Required Date: 1/21/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  HandFinish Hand Finishing	HandFinishing  Memo ✓ Wing Walk as per Dwg 3438 and QSI 005 4.4 Mask off 0.5 each side of D2561 lugs	0.00 0.00							
				11115790					
				=> del 11/01/21		2	0		
200  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00							
210  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00 0.00							
				PAN65247					

*1/11/25*

*1/11/25 (2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Item ID: D3438-042

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Start Date: 1/10/11 Start Qty: 2.00



Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/27  
CL110126

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





January 10, 2011 10:45:26 AM

**Parent Item Name:** Step Weldment Assembly

**Required Date:** 1/21/11

**Required Qty: 2.00**

**Comments:** IPP A05.05.18New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2244-116  Step Extrusion		Manufactured	No			100	Each	106.0000	1	2		11.01.14	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA			106						
					57850		29				2		
					60307		77						
D2561  Lug		Manufactured	No			100	Each	11.0000	2	4		11.01.17	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA			11						
					60096		11				4		
D2673-34  End Plate		Manufactured	No			100	Each	148.0000	2	4		11.01.17	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA			148						
					57527		1				4		
					59690		147						
D2564  Mounting Angle		Manufactured	No			110	Each	21.0000	2	4		11.01.17	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA			21						
					60097		1				1		
					62951		20				3		

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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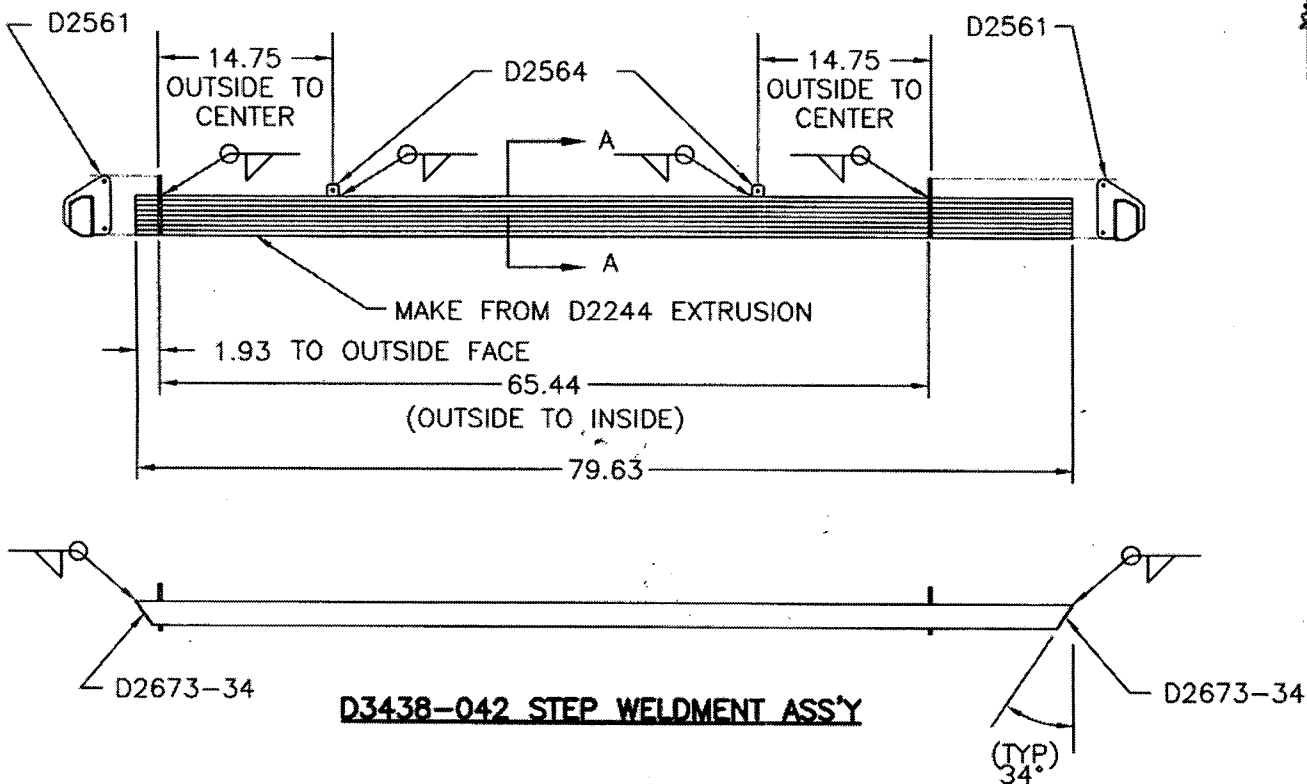
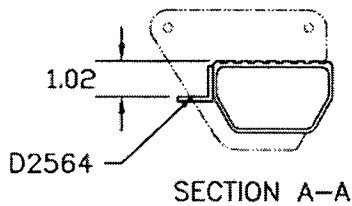
**NOTE:** Date & initial all entries

**DART**

RELEASED

05.05.09

# 65246



**NOTES:**

- 1) WELD PER DART QSI 004
- 2) TOLERANCES ARE PER DART QSI 018
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) FINISH: ACID ETCH & ALODINE PER QSI 005 4.1, POWDER COAT WHITE PER QSI 005 4.3.5.1  
WING WALK TOP PER QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS

DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.05.09	TITLE	D3438	REV. A
		STEP WELDMENT ASSEMBLY		SHEET 1 OF 1
		NEW ISSUE		SCALE 1:1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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